



Steel Industry

Non-contact Length and Speed
Measurements: Precise, Reliable,
Repeatable

Competence Field



Polytec LSV: When The Going Gets Tough



Polytec's line of LSV laser length & speed sensors are specifically designed to deliver precise and reliable measurements for advanced process control, process optimization, improved quality and increased yield. From Casting to Finishing, the LSV offers a comprehensive range of sensor systems and accessories to enable optimal configuration for the specific application requirements.

With over 20 years experience in the industry, customers have come to rely on Polytec to supply advanced, reliable technology in a rugged, mill-duty package, while providing the attention to customer support responsible for building long term business partnerships. Polytec's LSVs provide length & speed solutions to many applications throughout the steel process including Casting, Hot Rolling, Cold Rolling, Coating, Plate Mills, Steel Processing, Tube & Pipe and much more. Whether the sensor is used for Process Speed, Cut-to-length or Length Verification, the LSV is the solution of choice for mills around the world.



- All-in-one system, easy integration into production processes and control environments
- ASA: Automatic Surface Adaption – Automatically compensates for changing surface conditions resulting in optimal measurements
- FBD: Fast Burst Detection – Allows the LSV to quickly lock on to and follow true velocity even at high accelerations
- Unrivalled depth of field at short Working Distances of the shifted systems. Proprietary Optics – Ideal for Tube and Pipe Applications
- Easy to operate with no recalibration within its lifetime
- Visible laser for easy alignment and operator safety
- Compact design fits into other measurement frames, like radiometric thickness C-frames
- Robust sensor technology for reliable operation even under harsh conditions, protection class IP66 and IP67
- Optional cooling, air purge and heavy duty housing for measurement tasks in challenging environments
- Includes two trigger inputs for additional photocells, hot Metal Detectors or external switches for high precision edge detection and off set length compensation
- Hardware status signals for remote diagnostic functions available
- User-selectable full quadrature pulse output and interfacing with LAN, RS 422/232, Profi bus and more
- Various working distances available from 300 mm to 2,500 mm
- Parallel Fringe Spacing: Proprietary optics produces outstanding parallel and consistent fringe spacing to guarantee accuracy regardless of position within the specified field





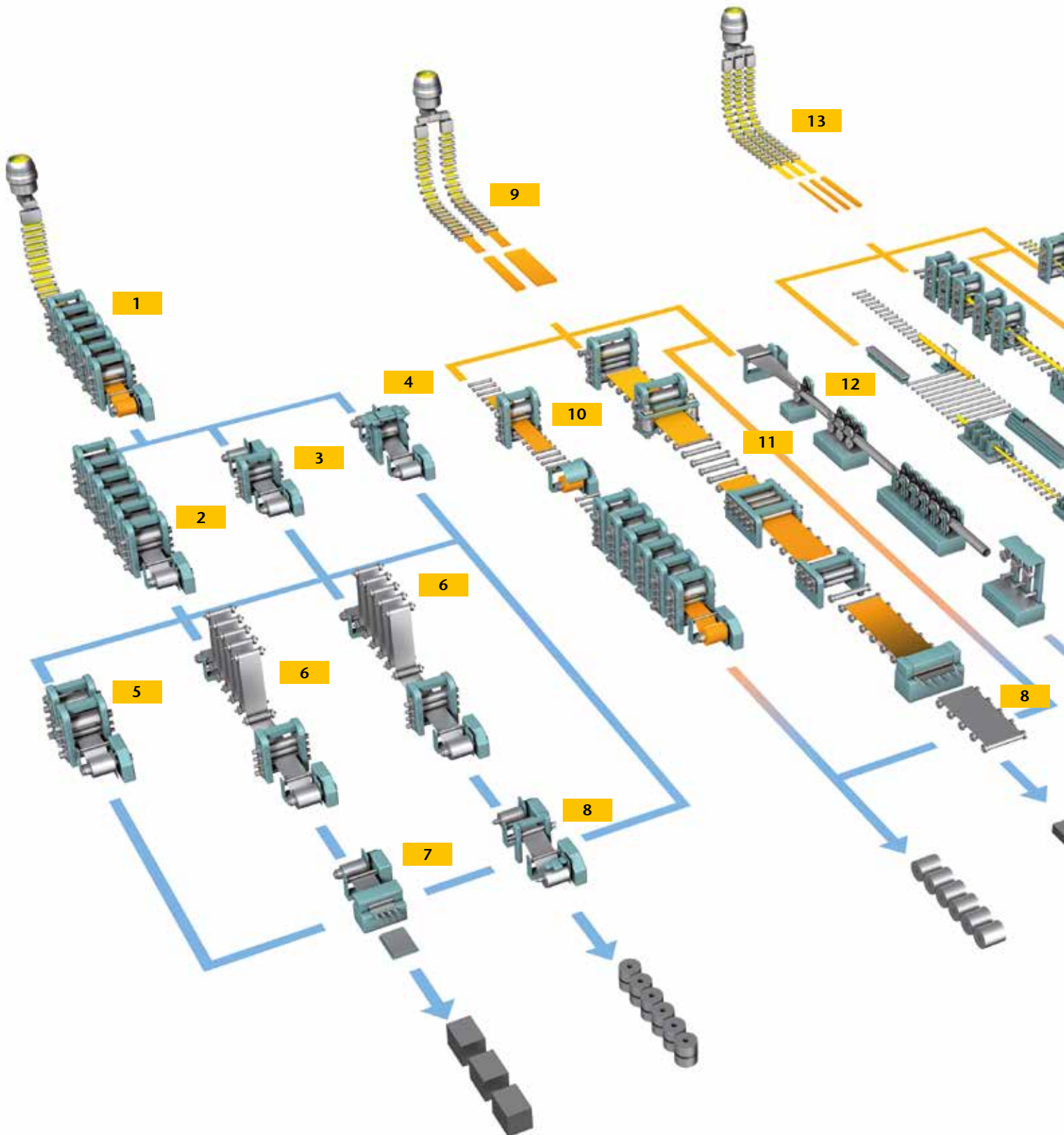
1
LSV with protection housings to measure casting speed and length in a billet caster

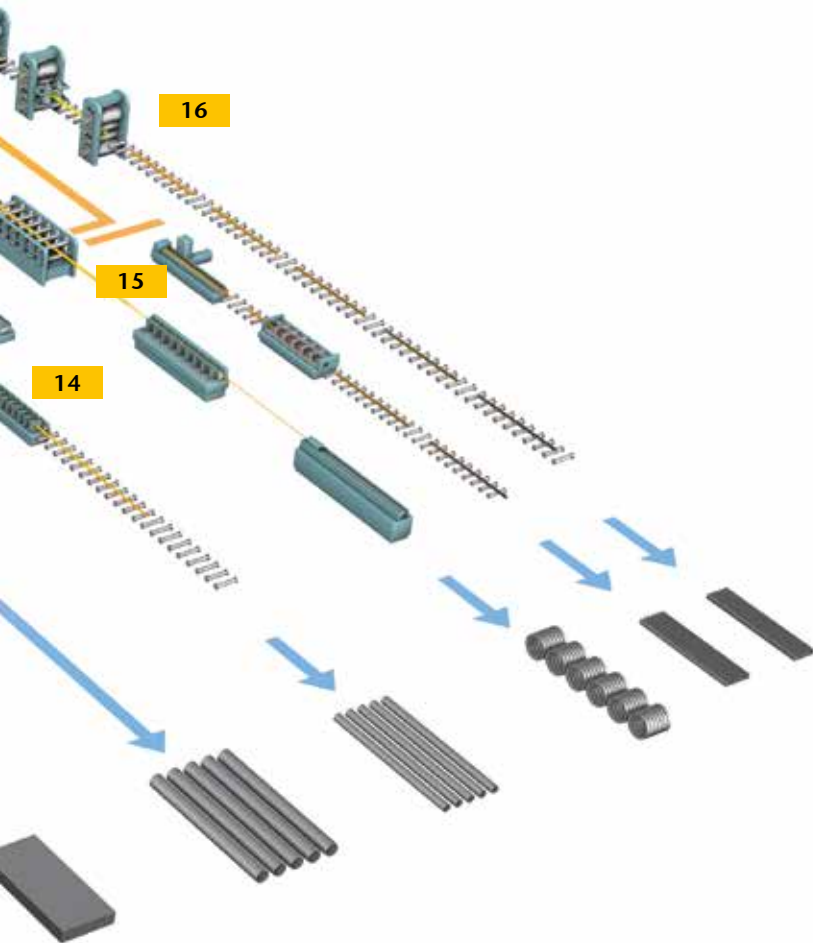
2
LSV with protection housing in a cold rolling mill for mass flow control

3
LSV measures rotation of a tube in a planetary cross rolling mill

4
Stand alone mounted LSV with protection housing in an oily and steamy environment of a cold rolling mill

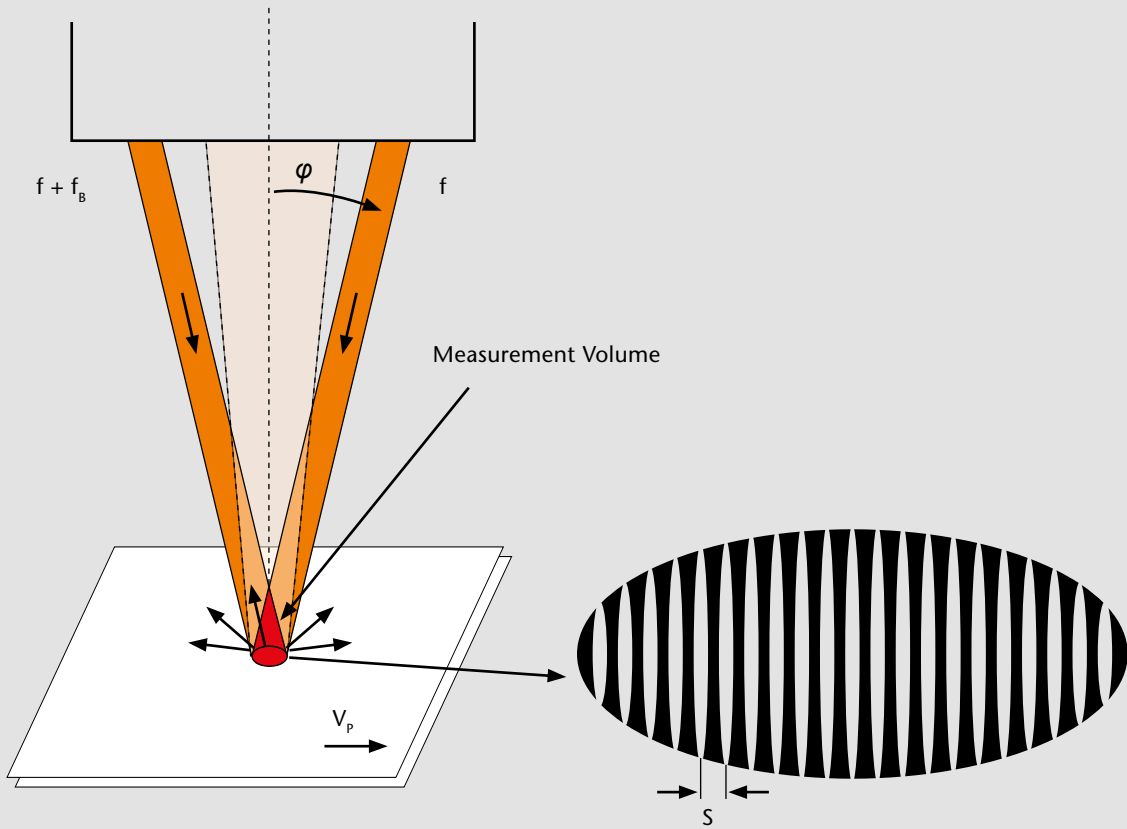
Multifunctional – Everywhere You Need It





Typical Applications

- 1** Hot strip speed measurement for coil box speed synchronization at the exit of a Continuous Strip Production, CSP
- 2** Interstand and exit strip speed measurement for mass flow control and automatic gauge control in tandem cold rolling mills
- 3** Entry and exit speed measurement for mass flow and elongation control in a reversing cold rolling mill
- 4** Entry and exit speed measurement for mass flow and elongation control in 20 high roll mill stand
- 5** Entry, Interstand and exit strip speed measurement for mass flow control and automatic gauge control in a tandem reversing cold rolling mill
- 6** Entry and exit speed measurement for elongation control in a temper / skin pass mill
- 7** Coil strip length measurement for dividing shear cut to length control
- 8** Final length measurement of coils
- 9** Length measurement of the continuous slab caster strands for torch cutter control for slab length optimization
- 10** Speed measurement for coil box synchronization and crop optimization in a compact hot strip mill
- 11** Speed measurement for cooling process control in laminary cooling sections
- 12** Length measurement for U plate positioning in presses in a large diameter pipe plant
- 13** Length measurement of the continuous long product caster strands for torch cutter control for billet and bloom length optimization
- 14** Length measurement in stretch reducing mills for seamless tubes, also in combination with wall thickness gauges
- 15** Speed measurement on rods for flying shear speed synchronization and cut to length control in rod mills
- 16** Length measurement on long products for cut to length control in section mills



Laser Surface Velocimetry: Built For Precision

Non-shift, Base systems

Polytec LSV Laser Velocimeters use a modified Laser Doppler technique to measure the speed of material passing by the sensor. The beam of a single laser diode is split into two beams. These beams are superimposed on to a moving surface at an angle φ , relative to the optical access. As the two beams overlap, constructive and destructive interference occurs, generating a static pattern of light and dark fringes within a specified measurement volume called the depth of field. The fringe spacing, Δs , a key calibration parameter, is determined by the wavelength λ and the angle φ , as defined by:

$$\Delta s = \frac{\lambda}{2 \cdot \sin\varphi}$$

Light scattered from a material moving through this pattern, experiences a doppler frequency shift, f_D , proportional to the speed of the material, as defined by:

$$f_D = \frac{v_p}{\Delta s}$$

The result is an intensity modulation at the receiving optics, with a frequency proportional to the velocity of the material. Length is then calculated by integrating velocity over time, in real time.

Frequency shifted systems

For those applications requiring material direction (forward/reverse) or measurement at and around standstill ($v=0$), a Bragg Cell is introduced into the optical path to shift one of the beams by a constant frequency of f_B – the Offset Frequency. The result is a fringe pattern that generates an intensity modulation as defined by:

$$f_M = f_B + f_D$$

Where:

f_M is the measured frequency

f_B is the offset frequency

f_D is the Doppler frequency

This frequency shifting technique enables measurement at standstill ($v=0$: where $f_D=0$ and $f_M = f_B$), as well as, detection of velocity direction (+ / -).

In both cases, system accuracy is dependent solely on Wavelength λ and Angle φ .

Accessories



LSV-A-110 Connection Box
 The Connection Box is completely wired for instant operation and contains a full terminal block, an universal power supply and LAN connector.



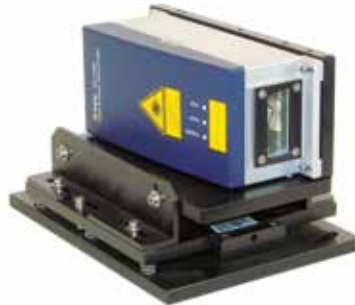
LSV-A-120 Air Wipe with quick exchange window
 A front-mounted, aerodynamically optimized air wipe unit keeps the sensor's optical window free of dust and steam. For cleaning or replacement, the quick release window can be easily exchanged.



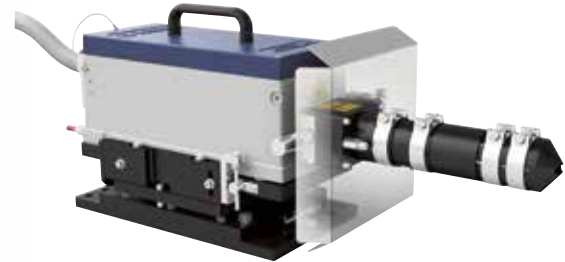
LSV-A-124 Measurement Installation Kit
 The C-Frame Accessory Kit allows an easy integration into the housing of a c-frame of any radiometric thickness gauge. A built-in cooling plate keeps the sensor within its operational temperature range.



LSV-A-122 Cooling Plate
 The cooling plate keeps the sensor in its operational temperature range, even under hot ambient conditions.



LSV-A-130 Adjustment-/ Mounting Platform
 The 3-axis adjustable mounting platform simplifies the precise alignment of the LSV sensor in relation to the measurement object.



LSV-A-121 Thermoprotective Housing
 To enable measurements in extreme environments Polytec has developed a high performance Thermoprotective housing. The LSV can be operated in with this housing and the optional Heat protection shield above a slab caster line without additional protection.



 **Polytec GmbH (Germany)**
 Polytec-Platz 1-7
 76337 Waldbronn
 Tel. +49 7243 604-0
 info@polytec.de

Polytec GmbH (Germany)
Vertriebs- und Beratungsbüro
 Schwarzschildstraße 1
 12489 Berlin
 Tel. +49 30 6392-5140

 **Polytec, Inc. (USA)**
 North American Headquarters
 16400 Bake Parkway
 Suites 150 & 200
 Irvine, CA 92618
 Tel. +1 949 943-3033
 info@polytec.com

Central Office
 1046 Baker Road
 Dexter, MI 48130
 Tel. +1 734 253-9428

East Coast Office
 25 South Street, Suite A
 Hopkinton, MA 01748
 Tel. +1 508 417-1040

 **Polytec Ltd. (Great Britain)**
 Lambda House
 Batford Mill
 Harpenden, Herts AL5 5BZ
 Tel. +44 1582 711670
 info@polytec-ltd.co.uk

 **Polytec France S.A.S.**
 Bâtiment Orion – 1er étage
 39, rue Louveau
 92320 Châtillon
 Tel. +33 1 496569-00
 info@polytec.fr

 **Polytec Japan**
 Arena Tower, 13th floor
 3-1-9, Shinyokohama
 Kohoku-ku, Yokohama-shi
 Kanagawa 222-0033
 Tel. +81 45 478-6980
 info@polytec.co.jp

 **Polytec South-East Asia Pte Ltd**
 Blk 4010 Ang Mo Kio Ave 10
 #06-06 TechPlace 1
 Singapore 569626
 Tel. +65 64510886
 info@polytec-sea.com